



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13135	
2	Machined By		U7L MIC Shop	45/60
3	Pallet Die No.		12857 (8-0)ms	Drngt - 1174 P <sup>co</sup>
4	Die Category	Drg. No.	M-8umbo	
5	Out Side Diameter	Drg. No.	720 mm Step OD - 693 mm	Step height - 20mm
6	Inside Diameter	Drg. No.	600 mm	
7	Width of Pellet Die	Drg. No.	292 mm	(Flapper 12°)
8	Grooves as per Drawing	Drg. No.	12x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping Hoaf
10	Drilling Area Surface Smoothness		OK	Holes - 12 Boths
11	Tapping Operator		MIC Shop	
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		M20 (check by M20 Bolt)	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 20 mm	Tapping Depth - 18.5 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Sanjeev 8/11/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		NO

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	φ 8.5	outside (3-3)	4MMRP		
3	External Relief Depth		23 mm	15mm		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		hark	pinou		
6	Material Sent For Hardening On Date		8	11	24	

### Inspected By (Sign) & Date

Sanjeev 8/11/24

Sanjeev 8/11/24

Reviewed by (Engineer-CNC)

Manager-QA